

### **SPECIFICATION**

Please amend the paragraph starting on page 3 line 10 as follows: --

During the heat up phase and until the tubular ends are pressed together to form a forge weld it is preferred to flush along the heated pipe ends a flushing fluid mixture comprising a mixture comprising less than 25% by volume of a reducing fluid, such as hydrogen or carbon monoxide and more than 75% by volume of a substantially inert gas, such as nitrogen, carbon dioxide and/or a noble gas, such as argon. ~~The flushing fluid mixture preferably comprises between 2 and 15% by volume of reducing fluid and between 85 and 98% by volume of a substantially inert gas.~~ --

Please insert the following two new paragraphs directly preceding the paragraph starting on page 3 line 21: --

The flushing fluid mixture may be formed in-situ in the form of a flushing fluid gas, by painting or spraying a liquid or solid reducing agent at the tubular ends and injecting an inert gas into said space, whereupon the reducing agent is at least partly evaporated when the tubular ends are heated and the evaporated reducing agent is mixed with the injected inert gas to form the flushing fluid gas. The liquid or solid reducing agent may comprise a cleaning liquid, such as hydrochloric acid, and a reducing agent, such as hydrogen peroxide, borax powder and/or an alkaline or beryllium hydride.

The flushing fluid mixture preferably comprises between 2 and 15% by volume of reducing fluid and between 85 and 98% by volume of a substantially inert gas. --

Please amend the paragraph starting on page 11 line 21 and bridging onto page 12 as follows: --

The first pair of electrodes 22, 23 is pressed against the outer surface of the tubular 21 and transmit a high frequency current 26 through the wall of the tubular 1 and the separation wall 29 as illustrated by arrows 27, 27A. An assembly of ferrite bars 28 serves to enhance the current density in the immediate vicinity of the ends of the tubular 21 and of the adjacent tubular (not shown). When the first diagonal set of electrodes 22, 23 are activated a majority of the high frequency electrical current will pass through the diagonal separation wall ~~[[28]]29~~, thereby predominately heating the end of said separation wall ~~[[28]]29~~, whereas when subsequently the second set of diagonal electrodes 24, 25 is activated a majority of the high frequency electrical current will pass through the wall of the tubular 21. The power supplied to the electrode sets 22, 23 and 24, 25 and the duration of the periods during which the electrode sets are

alternatingly activated is controlled such that the ends of the walls of the tubular 21 and of the separation wall 29 are heated uniformly to a predetermined temperature. --